

Date: Thursday, 10/11/2007 2:54:58 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 35134		
Estimate Number	: 11181		
P.O. Number	: <u>N/A</u>	Part Number	: D32941
This Issue	: 10/11/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3294 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 33122	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 11/5/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
-----	-------------	--------------------



Comment: Qty.: 2.1072 sf(s)/Unit Total : 21.0725 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick
 (M2024T3S.080)
 Identify for D3294-1
 Batch: M105411 B07-10-18

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3294
 Dwg Rev: M
 Prog Rev: M

B07-10-182-Deburr if necessary B07-10-18

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Go 07/10/18counts
(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

n/a Don at step #22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 07/11/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/11/00</u>	<u>1</u>							

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 35134

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



(P2)

Comment: NC BRAKE

Form as per Dwg D3294

SB 07/10/26 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



coated

Comment: INSPECT WORK TO CURRENT STEP

S 07/10/26 (P2)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(9)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-10-31

9.0

POWDER COATING

POWDER COATING



(9)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BR 07-10-31

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

07/10/01 (9)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 211

(x9) 07/11/01 AS E

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/02

Job Completion



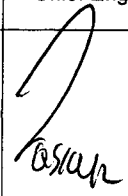



U 07/11/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/31	#60	one window from D32941 cracks while bending R.C. Material cracks one is white		Scrap and Destroy no Replace	SD 07/10/31	 07/10/31		 07/10/31

NOTE: Date & initial all entries

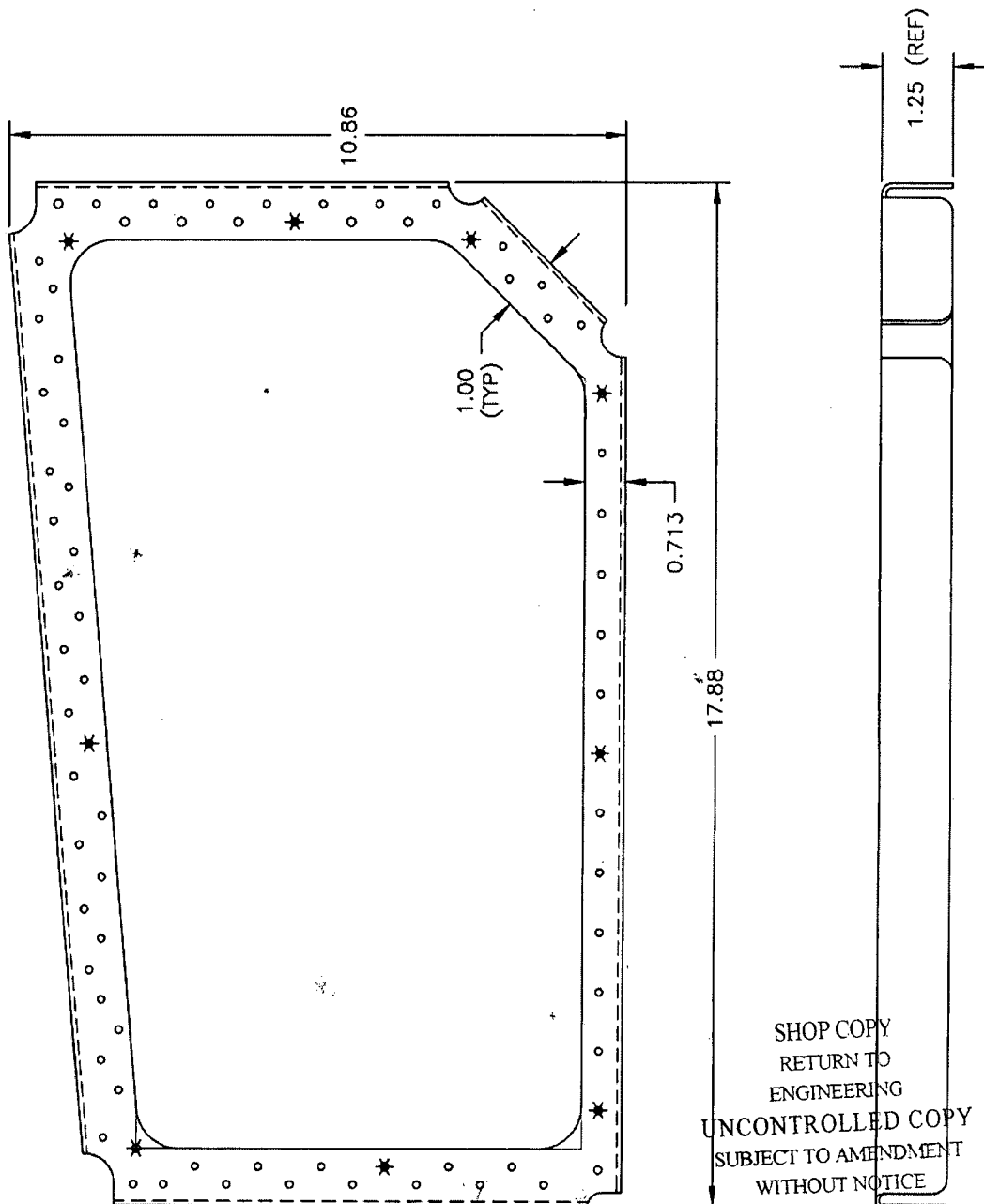


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	TH	APPROVED	TH	DRAWING NO.	REV. A
				D3294	SHEET 1 OF 2
DATE	04.06.28	TITLE	BRACKET	SCALE	1:3
A	04.06.28	NEW ISSUE			
AI	05.06.13	12.97 WAS 13.03, AS MANUFACTURED			

RELEASED
04.07.12

D3294-1 BRACKET

- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
- 2) CHECK PER TEMPLATE D3294-1T1
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 5) USE MINIMUM BEND RADIUS OF 0.188"
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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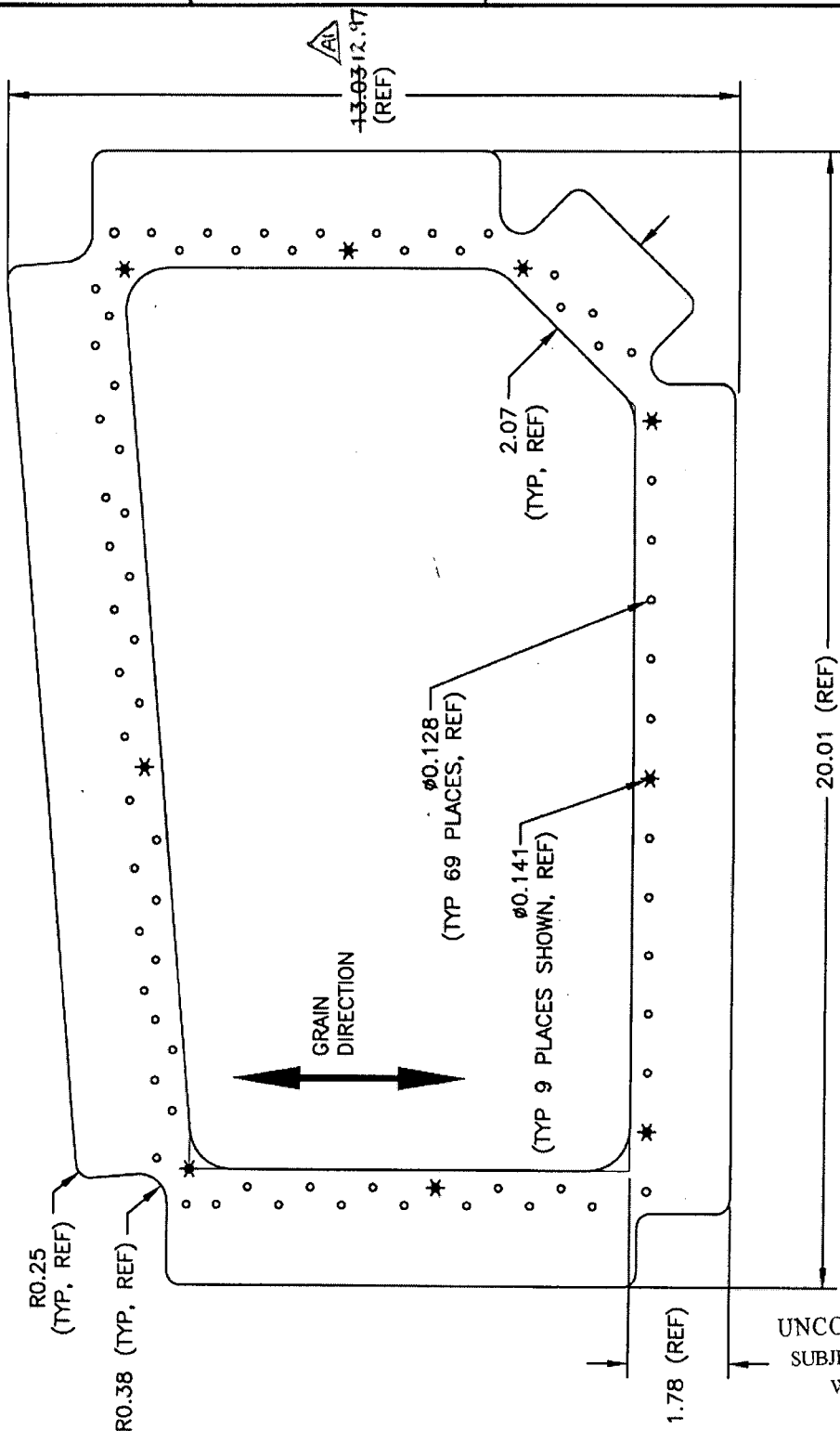
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3294	REV. A SHEET 2 OF 2
DATE 04.06.28		TITLE BRACKET	SCALE 1:3

D3294-1 FLAT PATTERN

RELEASED
R 04.07.12 H



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